

4/04

DART AEROSPACE LTD	Work Order:	20167
Description: Bearpaw Kit (13" x 16")	Part Number:	K10005
Dwg: D2671 Rev. B1	Qty:	4 Kits
Ref: K10005 Rev. A		Page 1 of 1






Step	Location	Procedure	By	Date	Qty																																																
1	DC	Issue Traveler Note: (1) K10005 Kit consists of Qty (2) D2671 Dwg not required	HA	04.01.09	4																																																
2	DC	Photocopy bluefile: K10005 D206-559-021 D500-572-021 and create labels per PPP K10005 CHG002 (Bag Bluefiles separately)	HA	04.01.09	4																																																
3	GA	Cut 2 blanks per (1) K10005 Kit Cut blank: 13.00" x 16.00" x 1.00" thick Material: Black UHMW 1" (MUHMWB10) Batch: 14416	EP	04/04/13	4																																																
4	MV	Inspect material for defects or damage prior to machining	EP	04/04/13	4																																																
5	MV	Machine as per Folio and Dwg D2671	EP	04/04/14	4																																																
6	QC2	Inspect parts as they come off the CNC machine	EP	04/04/14	4																																																
7	MV	Deburr	EP	04/04/14	4																																																
8	QC8 & 5	Second inspection	EP	04-04-14	4+																																																
9	KP	Pick: Packing Kit (Note: D2671 is on the BOM as material from step 3) <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>4 ✓</td><td>D2182B050</td><td>Rubber Cushion</td><td>B19540</td></tr><tr><td>8 ✓</td><td>D2274</td><td>Radius Block</td><td>B19599</td></tr><tr><td>2</td><td>D2671</td><td>Bearpaw</td><td>B20167</td></tr><tr><td>4 ✓</td><td>D2438</td><td>Clamp</td><td>B19615</td></tr><tr><td>8 ✓</td><td>D2529</td><td>Washer</td><td>B20090</td></tr><tr><td>8 ✓</td><td>AN4-15A</td><td>Bolt</td><td>M13437</td></tr><tr><td>8 ✓</td><td>AN4-17A</td><td>Bolt</td><td>M13437</td></tr><tr><td>16 ✓</td><td>AN960JD416</td><td>Washer</td><td>M13719</td></tr><tr><td>8</td><td>MS21042L4 ✓</td><td>Nut (or -4)</td><td>M13276</td></tr><tr><td>2 ✓</td><td>QS200M44S</td><td>Clamp</td><td>M4913/M14019</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></tbody></table>	Qty	Part Number	Description	Batch	4 ✓	D2182B050	Rubber Cushion	B19540	8 ✓	D2274	Radius Block	B19599	2	D2671	Bearpaw	B20167	4 ✓	D2438	Clamp	B19615	8 ✓	D2529	Washer	B20090	8 ✓	AN4-15A	Bolt	M13437	8 ✓	AN4-17A	Bolt	M13437	16 ✓	AN960JD416	Washer	M13719	8	MS21042L4 ✓	Nut (or -4)	M13276	2 ✓	QS200M44S	Clamp	M4913/M14019	1	Paperwork package from Step 2			EP	04/04/16	4
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10	QC4	Inspect Kit for 100% Completeness on the W/O	U	04.04.16	4																																																
11	PK	Identify and pack for shipping as per PPP K10005 Rev. C	EP	04/04/16	4																																																
12	AC	Cost / part 149.18 D 26.71 59.60	SUC	04-04-20	4																																																
13	DC	Close W/O 149.18 Inspect Level 21	HA	04.04.21	4																																																

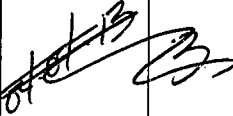
PTO

Rev	Date	Change	Revised By	Approved
A	99.12.17	K10005 created for Bearpaw Kit	EC	
B	03.05.28	Reformat; Incorporated D2671	KJ/RF	

B/P
04-11-20RELEASED
03.06.10

Dart Aerospace Ltd

Work Order:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector	
04-04-16	9	1x D2671 extra identify + stock	U	04-04-16	1	 04-04-21	 04-04-21	
04-04-16	3	CHANGE BLANK SIZE TO 13'14" x 16" PERMANENT CHANGE.		04-04-16	1	 04-04-21	 04-04-21	

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					
								

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	20167
Description: Bearpaw		Part Number:	D2671
Inspection Dwg: D2671 Rev: B1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.063 x 45°	✓		vern	
B	5.500	+/-0.030	5.495	—		vern	
C	0.200	+/-0.030	0.190	—		vern	
D	R0.250	+/-0.030	0.250	—		Radius Gauge	
E	0.625	+/-0.030	0.623	—		mic	
F	0.250	+/-0.010	0.250	—		mic	
G	0.950	+0.030/-0.010	0.948	—		vern	
H	0.25 x 45°	+/-0.030	0.25 x 45°	✓		vern	
I	0.375	+/-0.010	0.376	—		vern	
J	12.750	+/-0.030	12.750	✓		TAPE MEASURE	
K	Ø0.260	+0.005/-0.000	Ø0.260	—		vern	
L	Ø0.93	+/-0.030	Ø0.925	—		vern	
M	0.30	+0.030/-0.000	0.31	—		vern	
N	4.250	+/-0.030	4.258	—		vern	
O	0.375	+/-0.030	0.385	—		vern	
P	2.000	+/-0.030	2.008	—		vern	
Q	4.250	+/-0.010	4.254	✓		vern	
R	9.000	+/-0.010	9.000	✓		vern	
S	15.750	+/-0.030	15.750	✓		TAPE MEASURE	

Measured by: CP	Audited by: [Signature]	Prototype Approval:	N/A
Date: 04/04/13	Date: 04.04.13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF	[Signature]

RELEASED

04.01.15

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jan 09, 2004
10:09 am

Work Order No : 0020167
Project Name : K10005
Project For : WK404
Work Order Type : Main
Main WO Number :
House Part Number : *K10005
Description : Bearpaw kit 13" x 16"
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 01-09-04
Est Finish Date : 01-22-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00